



Dart Aerospace Ltd.
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D2221
Job Sheet 169037-A



Part No: D2221

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/29/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV H IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N 10.06.29 added pressure wash DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/11/18	0.00	0.00	Start Up Large Fab-2		DC 2018-01-29
100	Large Fab	1 pcs		1/11/18	0.00	10.00	Large Fab 1		1/18-01-29
110	QC	1 pcs		1/11/18	0.00	0.00	QC9		1/18-01-29
120	QC	1 pcs		1/11/18	0.00	0.00	QC5		1/18-01-29
125	HandFinish	1 pcs		1/11/18	0.00	0.35	HandFinish2		1/18-01-30
130	Powdercoat	1 pcs		1/12/18	0.00	0.81	Powdercoat2		1/18-01-30
140	QC	1 pcs		1/12/18	0.00	0.00	QC3		1/18-01-30
150	Packaging	1 pcs		1/12/18	0.00	0.00	Packaging3		1/18-01-31
160	QC21-SA	1 Ea		1/12/18	0.00	0.00	QC21		JAN 31 2018

Part Op 100 - 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld Descriptions: D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: *****PLEASE NOTE SEE DWG*** IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG
130 - 1- Plug holes prior to 1ST COAT: START TIME: 1:40 OVEN TEMPERATURE: 375° FINISH TIME: 1:50 ***** 2nd coat if necessary ***** 2ND COAT: FINISH TIME: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2221-1 160533	1	9	0	0
	160534-D2221-5	2	6	0	0
	D2221-7 5006413	1	4	0	0
	D2232-3 5006414	2	16	0	0
	D2235-1 160535	2	8	0	0
	D2581 5033599	2	71	0	0
	D3442-1 142837	2	19	0	0
	D3825-041 3031558	2	1	0	0
	D3826-041 160526	2	6	0	0
	D3827-041 160529	1	3	0	0
	146407-D3833-1	2	6	0	0
	M304EX0.75-16F 5021100	27	476	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S035737

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Basket Base Assembly

PART NO: D2221
Original Serial #: S035737
Revision:
Operation: Start up Operation
Change No:

01/25/18
Job No: 169037 - A